

Date Opened: 05 December 2013
Job #: 786
Project: Mounting Beams
Type: Eurocopter AS350/AS355
Approval: SH08-16
Drawing List: DCL786-3, Rev. 3

Fabrication and Assembly Drawing(s)Description

10 of 10 78633, Rev. 1 Aft Beam Fabrication
10 of 10 78634, Rev. 1 Forward Beam Fabrication

Before Matt
Started

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record: Y
Document Control List revision level matches (or exceeds) STC: Y
Drawings revision levels match Document Control List: Y
Purchase order or Work order source is recorded for each part/ass'y: Y
Tests and inspections specifically called out on drawings are complete: Y
Release tags associated with all fabricated parts are attached: Y
All mounting hardware and supplies are included: Y

List all non-conformities raised: _____

Inspector Signature: _____

Date: _____

Drawing: 78633 Revision 1
 Assembly: 78633-01-01 Aft Beam Ass'y (RH)
 Batch Quantity: 10

Qty	Part #	Description	Material	P.O./W.O.	Checked
10	78633-01-01	Aft Beam Assembly (RH)			
. 1	78633-02	Tube	1x2x0.065 Tube, 304 Stainless Steel	12091	
. 4	78633-03	Guide	1x0.125 Bar, 304 Stainless Steel		
. 1	78633-04	Upper Guide	1x2x0.12 Tube, 304 Stainless Steel		
. 4	78633-05	Stop Bracket	0.75x0.065 Sqr. Tube, 304 Stainless	2013-58	
. 1	78633-06	Cap	0.025" Sheet, 321 Stainless Steel	2013-29 B#10037	
. 4	78630-04	Bushing	0.375 x 0.065 Tube, 304 Stainless Steel		
. 1	82735-03	Tube	1.0 x 0.035 Tube, 316 Stainless Steel	W#2013-58 B#12093	
. 1	82735-06	Cap	0.050 Sheet, 321 Stainless Steel	W#2013-58 B#10037	

Processes	Per	Mat'ls Used	Initials
Welding	AMS 2685C	Welding Rod ER308L and ER347	AD-05
Powder Coat	Drawing 78633	PO	
Final Inspection	Drawing 78633		

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 78634 Revision 1
 Assembly: 78634-01-00 Beam Ass'y
 Batch Quantity: 10

Qty	Part #	Description	Material	P.O./W.O.	Checked
10	78634-01-00	Forward Beam Assembly			
. 1	78634-02	Tube	1x2x0.065 Tube, 304 Stainless Steel	12091	
. 5	78634-03	Pad	1x0.125 Bar, 304 Stainless Steel	13077	
. 1	78634-04	Cap	0.025" Sheet, 321 Stainless Steel	PO# 10037	
. 4	78630-04	Bushing	0.375 x 0.065 Tube, 304 Stainless Steel		
. 2	69830-11	Guide	0.75 x 0.065 Tube, 304 Stainless Steel	PO# 2013-38 B# 12093	
. 2	69830-21	Stop	0.625 Rod, 6061-T6 Aluminum		
. 2	69830-22	Knob	0.75 Rod, 6061-T6 Aluminum		
. 2	69830-23	Spring	15mm x 70mm Spring, Stainless Steel		
. 2		#10-32 C'sunk screw	Stainless Steel		
. 2	MS21044C3	Nut			
1	69830-07	Block	S.S. 304	WO# 2013-31	

Processes	Per	Mat'ls Used	Initials
Welding	AMS 2685C	Welding Rod ER308L and ER347	AD-05
Powder Coat	Drawing 78634	PO	
Final Inspection	Drawing 78634		

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

MOUNTING BEAM FABRICATION – 78633/78634

General

These instructions apply to mounting beams 78633-01 (aft) and 78634-01 (forward) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

78633, Revision 1 – Aft Beam

78634, Revision 1 – Forward Beam

Work Order: 2013-58

Batch Quantity: 10 aft
10 forward

Complete
(initial or SCA #)

Date Open: Dec 5/2013

1. Beam Fabrication – 1x2 tubes – 78633-01 / 78634-01

- Cut 1 x 2 x 0.065 material as indicated on drawings.
 - 78633-02 – 24.44"
 - 78634-02 – 24.25"
- Cut 1 x 2 x 0.120 material @ 16.38" long for upper guide (10).
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

2. CNC Machining – 78633-01 / 78634-01

- Run CNC programs to machine slots and holes in 78633-02 tubes and 78634-02 tubes.
- Run CNC programs to machine blanks for upper guides.
- De-burr slots and holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

ADO2

3. Beam Fabrication – Components – 78633-01

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- Shear caps from 0.025" sheet: 78633-06
- Cut 78633-03 guides from 1x1/8 stock.
- Cut and turn 78630-04 bushings from 3/8 x 0.065 tube:
 - Cut stock to length + 0.03-0.06".
 - Face one end flat @ 1000 RPM.
 - De-burr outside with a file and inside with de-burring tool at 300 RPM.
 - Setup stop and face other end to length @ 1000 RPM.
 - De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- Cut 78633-04 upper guides from blanks machined in step 2.b.
- Cut 78633-05 stop brackets from 0.75 x 0.065 tube.
- Cut 82735-03 step tubes from 1.0 x 0.035 tube.
- Punch 82735-06 step cap from 0.050 sheet, 1.25 diameter. Flatten on steel table with a hammer.

- h. Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.

4. Beam Fabrication – Components – 78634-01

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- a. Shear caps from 0.025" sheet: 78634-04.
- b. Cut 78634-03/78634-11/78634-12 pads from 1x1/8 stock.
- c. Cut and turn 69830-11 guide tubes from $\frac{3}{4}$ x 0.065 tube:
 - i. Cut stock to length + 0.03-0.06".
 - ii. Face one end flat @ 1000 RPM.
 - iii. De-burr outside with a file and inside with de-burring tool at 300 RPM.
 - iv. Setup stop and face other end to length @ 1000 RPM.
 - v. De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- d. Cut 69830-07 blocks.
- e. Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.

5. Beam Welding – 78633-01

AD-05

- a. TIG weld 78633-03 guide, 4 places, and 78633-04 upper guide into 78633-02 tubes using ER308L rod.
 - i. Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
- b. Record component and welding rod POs / WOs on attached material list.
- c. Tag in-progress parts for straightening.

6. Beam Welding – 78634-01

AD-05

- a. TIG weld 78634-04 pad, 3 places; 78634-11 pad, 1 place; and 78634-12 pad, 1 place, into 78634-02 tube.
 - i. Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
- b. Record component and welding rod POs / WOs on attached material list.
- c. Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

7. Beam Straightening – 78633-01 / 78634-01

AD-02

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.

- a. Set beam on blocks as far apart as possible on hydraulic press.
- b. Use a 2" block to distribute press loads.
- c. Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- d. Check for straight with a straight edge on back of tube.
- e. 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- f. Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

AD-02

8. CNC Machining – 78633-01 / 78634-01

- Run CNC programs to machine keyways and slots in 78633-02 tubes with guides welded in place, after straightening.
- Run CNC programs to machine keyways and slots in 78634-02 tubes with pads welded in place, after straightening.
- De-burr keyways and slots.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

9. Beam Welding – 78633-01

- De-burr slots/keyways*
- Clean up weld on end cap.*
- Peg step: TIG weld 82735-06 cap to 82735-03 tube using jig to align cap to tube.
 - TIG weld 78633-04 bushings into 78633-02 tube using ER308L rod, four places per tube, both sides. *should be "O" DRM*
 - TIG weld 78633-05 stop bracket to 78633-02 tube using ER308L rod, four places per tube, both sides. Use jig to align stop brackets for height and position. *Be sure to clamp brackets to jig. check for flush fit.*
 - TIG weld 78633-06 cap to 78633-02 tube.
 - TIG weld step tube assembly from a. to back of 78633-02 tube using jig for alignment. Weld around step tube as far as possible, then close out tube by flattening protruding edge of step tube with a hammer. Complete weld after flattening.
 - Record component and welding rod POs / WOs on attached material list.
 - Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

10. Beam Welding – 78634-01

- Check jig pin for fit in key hole.*
- TIG weld 69830-11 guide tubes into 78634-02 tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. *Grind rosette welds flush.*
 - TIG weld 78633-04 bushings into 78634-02 tube using ER308L rod, four places per tube, both sides.
 - TIG weld 69830-07 block to 78634-02 tube over 3rd keyway (see drawing) using ER308L rod.
 - TIG weld 78634-04 cap to 78634-02 tube. Ensure 0.25" gap between cap and pad for basket fitting to enter top keyway.
 - Record component and welding rod POs / WOs on attached material list.
 - Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

11. Beam Finishing – 78633-01 / 78634-01

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

- Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
- Use a 2" block to distribute press loads.
- Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
- Check for straight with a straight edge on back of tube.
- 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
- Drill out bushings to F (0.257"), four places per beam, on drill press.
- Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
- Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

12. Final Inspection – 78633-01 / 78634-01

To be completed by a different person than the previous steps.

- a. Inspect beams 78633-01 and 78634-01 for conformity to drawings.
- b. Tag in-progress parts ready for powder coating.

13. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag in-progress parts ready for final assembly.

14. Final Assembly – 78633-01

To be completed after powder coating.

- a. Prepare step tube for grip tape by rubbing top surface with scotch-brite.
- b. Adhere 1" 3M Safety-Walk grip tape to top surface of step tube.
- c. Adhere P/N placard to back surface of beam.
- d. Ensure AN4 bolt can be inserted through bushings.
- e. Green tag complete beam assembly and place into stock.

15. Final Assembly – 78634-01

To be completed after powder coating.

- a. Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- b. For 776 (short), 764 (medium) or 784 (long) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into UPPER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- c. For 940 (extra large) basket installation: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into LOWER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- d. If maintenance step is to be installed: Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into LOWER guide with 69830-22 knob and MS21044C3 nut. Check for function.
- e. Adhere P/N placard to back surface of beam.
- f. Green tag complete beam assembly and place into stock.

WO: 2013-58
 Drawing: 78633 Revision 1
 Description: AS350 Aft Beam Assembly

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>10</u>		78633-01-XX	Aft Beam Assembly (XX = -01 RH, -02 LH)		
Step 1	.1		78633-02	Tube	1x2x0.065 Tube, 304 Stainless Steel	
Step 1	.1		78633-04	Upper Guide	1x2x0.12 Tube, 304 Stainless Steel	<u>PO# 12091</u>
Step 2				Machning	None	
Step 3	.4		78633-03	Guide	1x0.125 Bar, 304 Stainless Steel	
	.4		78633-05	Stop Bracket	0.75x0.065 Sqr. Tube, 304 Stainless	
	.1		78633-06	Cap	0.025" Sheet, 321 Stainless Steel	
	.4		78630-04	Bushing	0.375 x 0.065 Tube, 304 Stainless Steel	<u># 11040</u>
	.1		82735-03	Tube	1.0 x 0.035 Tube, 316 Stainless Steel	
	.1		82735-06	Cap	0.050 Sheet, 321 Stainless Steel	
Step 5				Welding Welding Rod	ER308L	<u>Using ER347 .035"</u>
Step 7				Straightening	None	
Step 8				Machning	None	
Step 9				Welding Welding Rod	ER308L	<u>ER347 .035"</u>
Step 11				Finishing	None	
Step 12				Final Inspection	None	
Step 13				Powder Coating		
Step 14				Final Assembly		
		--		Grip Tape	1" 3M Safety Walk	
		--		P/N Placard	TZ tape, 1/2", white on black	

WO: 2013-58
 Drawing: 78634 Revision 1
 Description: AS350 Forward Beam Assembly

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 1	<u>10</u> .1		78634-01-00 78634-02	Forward Beam Assembly Tube	1x2x0.065 Tube, 304 Stainless Steel	
Step 2				Machning	None	
Step 4	.5 .1 .4 .2		78634-03 78634-04 78630-04 69830-11 78634-11	Pad Cap Bushing Guide Pad	1x0.125 Bar, 304 Stainless Steel 0.025" Sheet, 321 Stainless Steel 0.375 x 0.065 Tube, 304 Stainless Steel 0.75 x 0.065 Tube, 304 Stainless Steel	<u>WO# 2013-58</u> <u>PO# 11040</u> <u>PO# 13077 WO# 2013-58</u>
Step 6				Welding Welding Rod	ER308L	<u>ER347 .035"</u>
Step 7				Straightening	None	
Step 8				Machning	None	
Step 10				Welding Welding Rod	ER308L	<u>ER347 .035"</u>
Step 11				Finishing	None	
Step 12				Final Inspection	None	
Step 13				Powder Coating		
Step 15				Final Assembly		
	.1		69830-21	Stop	0.625 Rod, 6061-T6 Aluminum	
	.1		69830-22	Knob	0.75 Rod, 6061-T6 Aluminum	
	.1		69830-23	Spring	15mm x 70mm Spring, Stainless Steel	
	.1		69830-1032X3	#10-32 C'sunk screw	Stainless Steel	
	.1		MS21044C3	Nut		
	.1		--	P/N Placard	TZ tape, 1/2" white on black	

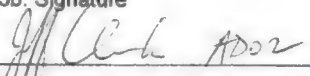


Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1
PN: 78634-01-00
Aircraft: Eurocopter
Model: AS350/355
Description: Forward Beam
Supplier: N/A
Color: White
WO#: 2013-11 58

PO# 14050

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2013-58	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	Forward Beam	78634-01-00	1	N/A	New	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke – AD02		13e. Date (dd/mm/yyyy) 16 Dec 2015		14d. Name		14e. Date (dd/mm/yyyy)
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

SELPARK MOUNTAIN

Aero Design

Parts Distribution Sheet

Description: Beam Pin

WO# 2013-58

[illegible]


Aero Design

Parts Distribution Sheet

Description: Beam Pin

WO# 2013-58

[illegible]

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2013-58	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
1.	RH Aft Beam	78633-01-01	1			
2.	Forward Beam	78634-01-00	1	N/A	New	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to:				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.						
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 14 Mar 2016		14d. Name		14e. Date (dd/mmm/yyyy)
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

AVIALTA

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2016-0140
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2013-58
6. Item 1.	7. Description Forward Beam	8. Part Number 78634-01-00	9. Qty. 1	10. Serial/Batch No. N/A	11. Status/Work New
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature <i>Jeff Clarke</i> AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mm/yyyy) 22 Aug 2016		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

HIGH TERRAIN



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1
PN: 78634-01-00
Aircraft: Eurocopter
Model: AS350/355

Description: Forward Beam

Supplier: N/A

Color: ~~White~~

WO#: 2013-11

Black ok

*Painted over
white JC.*

PO# 14050



WO# _____

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

Aero Design

Parts Distribution Sheet

Description: Beam Pin

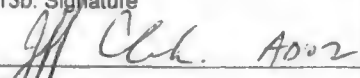
WO# _____

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WO#

Approved Manufacturing Facility 73-04

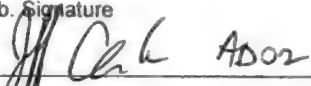
Rev. Original 27 May 2013

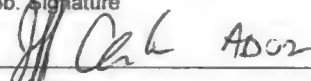
1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2013-58	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
1.	RH Aft Beam	78633-01-01	1			
2.	Forward Beam	78634-01-00	1	N/A	New	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.			<input type="checkbox"/> Other regulation specified in block 12			
<input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature		13c. Approved Organization Number		14b. Signature		14c. Approved Organization Number
 AD02		AMF 73-04				
13d. Name		13e. Date (dd/mmm/yyyy)		14d. Name		14e. Date (dd/mmm/yyyy)
Jeff Clarke - AD02		05 Oct 2015				
Installer Responsibilities						
This certificate does not constitute authority to install.						
Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.						
Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.						

ALTAI AIR RUSSIA

Didn't go?

slm assigned to west
(east)

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.		
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2013-58		
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work		
1.	RH Aft Beam	78633-01-01	1				
2.	Forward Beam	78634-01-00	1	N/A	New		
12. Remarks							
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release				
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.			<input type="checkbox"/> Other regulation specified in block 12				
<input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.				
13b. Signature		13c. Approved Organization Number		14b. Signature		14c. Approved Organization Number	
		AMF 73-04					
13d. Name		13e. Date (dd/mmm/yyyy)		14d. Name		14e. Date (dd/mmm/yyyy)	
Jeff Clarke – AD02		25 Feb 2015					
Installer Responsibilities							
This certificate does not constitute authority to install.							
Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.							
Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.							

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2013-58
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	RH Aft Beam	78633-01-01	1		
2.	Forward Beam	78634-01-00	1	N/A	New
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
<input type="checkbox"/> Non approved design data specified in block 12.					
13b. Signature  AD02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 25 Feb 2015		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

IMS RETURNED UNUSED - 06 MAR 2017 AD02
SENT TO HORIZON HELICOPTERS - 12 MAY 2017 AD02



Description: _____

[illegible]



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

In Process

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 45350 Fwd Mounting Beam QTY 10

Manufacturer: AERO Design

Part No.: 78634-01 Serial / Batch No.: PO 12091

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2013-58

Remaining Tasks to be Performed: Require step (11) beam straightening.
AD-05

Signature: [Signature]

Date: Dec 6/2013 Lic. No. / ACA AD03

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

In Process

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: A-350 Aft Mounting Beam QTY 10

Manufacturer: AERO Design

Part No.: 78633-01 Serial / Batch No.: PO 12091

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2013-58

Remaining Tasks to be Performed: Require step (1) beam straightening
AD-05.

Signature: Cathy Zinnall

Date: Dec 6/2013 Lic. No. / ACA ADO3

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 05 STOP BRACKET No. of pieces: 40

Manufacturer: AERO DESIGN

Part No.: 78633-05 Serial / Batch No.:

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2013-58

Remaining Tasks to be Performed:_____

Signature: 

Date: JAN 7, 2014 Lic. No. / ACA AD06

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 17 TUBE No. of pieces: 10

Manufacturer: AERO DESIGN

Part No.: 82735-03 Serial / Batch No.: 12093

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2013-58

Remaining Tasks to be Performed: _____

Signature: [Signature]

Date: Jan 7 2014 Lic. No. / ACA AD06

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 09 CAP No. of pieces: 10

Manufacturer: AERO Design

Part No.: 82735-06 Serial / Batch No.: 10037

TTSN: W/A TSO: W/A Rem.: N/A

Work Order No.: 2013-58

Remaining Tasks to be Performed: _____

Signature: [Signature]

Date: Jan 7 2014 Lic. No. / ACA AD06

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Bushing No. of pieces: _____

Manufacturer: AERO Design

Part No.: 78030-04 Serial / Batch No.: PO 11040

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2013-58

Remaining Tasks to be Performed: turn Face³ Down on lathe

Signature: Cushion

Date: Dec 11 2013 Lic. No. / ACA AD03

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Pod No. of pieces: 10

Manufacturer: AERO Design

Part No.: 78634-11 Serial / Batch No.: PO 13077

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2013-58

Remaining Tasks to be Performed: _____

Signature: Timothy Smith

Date: Dec 9/2013 Lic. No. / ACA AD03

In Process



Aero Design Ltd.


9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

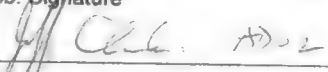
AMF 73-04

Remarks

In Process

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2013-58
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	RH Aft Beam	78633-01-01	1		
2.	Forward Beam	78634-01-00	1	N/A	New
12. Remarks Black					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 27 Jan 2014		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

LAPCUSE

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.		
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2013-58		
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work		
1.	RH Aft Beam	78633-01-01	1				
2.	Forward Beam	78634-01-00	1	N/A	New		
12. Remarks Red							
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release				
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.			<input type="checkbox"/> Other regulation specified in block 12.				
<input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the <i>Canadian Aviation Regulations</i> .				
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 19 June 2015		14d. Name		14e. Date (dd/mmm/yyyy)	
Installer Responsibilities							
This certificate does not constitute authority to install.							
Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.							
Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.							

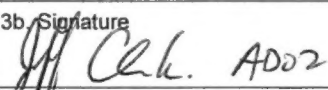
COPIED IN

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2013-58
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	RH Aft Beam Ass'y	78633-01-01	1	N/A	New
2.	Forward Beam Ass'y	78634-01-00	1	N/A	
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			 14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations. 		
13b. Signature <i>Jeff Clarke</i> AD02		13c. Approved Organization Number AMF 73-04		14c. Approved Organization Number	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mm/yy) 04 Dec 2014		14e. Date (dd/mm/yy)	
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

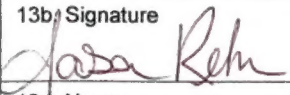
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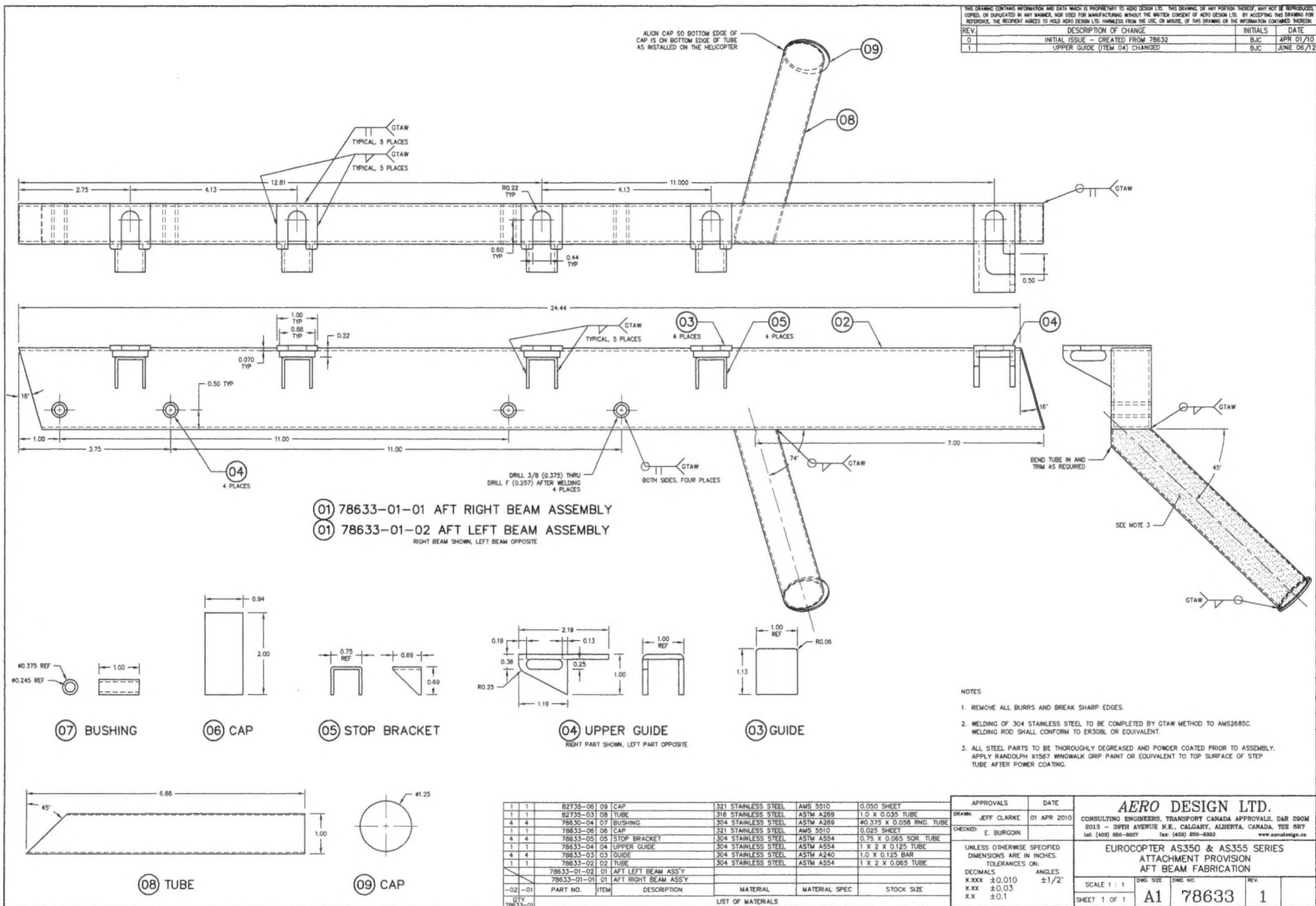
1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2013-58	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
1.	RH Aft Beam	78633-01-01	1			
2.	Forward Beam	78634-01-00	1	N/A	New	
12. Remarks Black						
13a. Certifies that the items identified above were manufactured in conformity to:				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature <i>Jeff Clarke</i>		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 21 Jan 2015		14d. Name		14e. Date (dd/mmm/yyyy)
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

14666

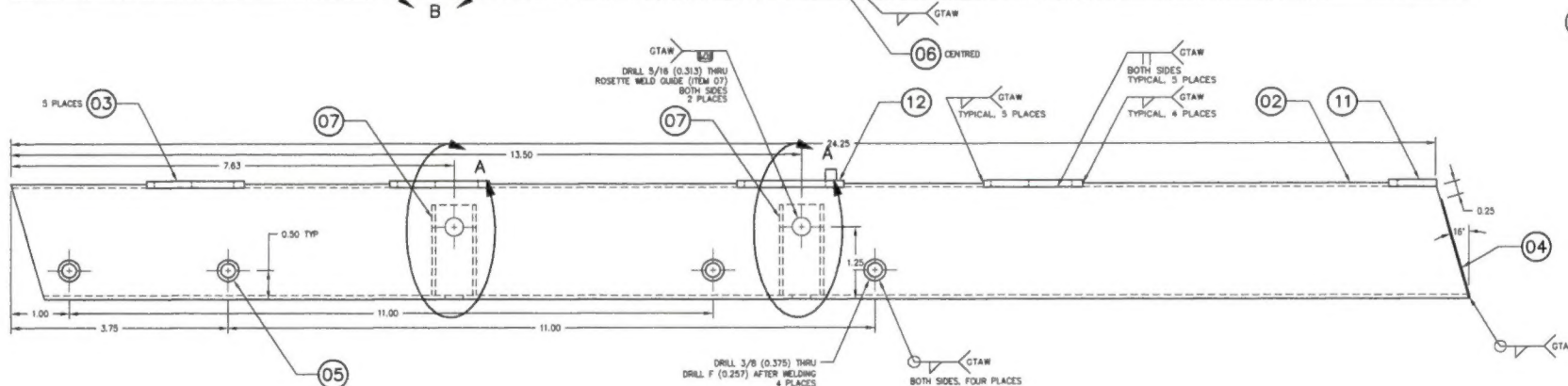
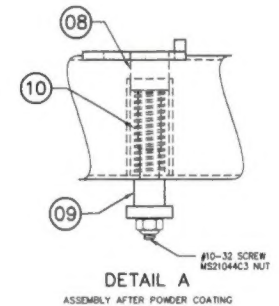
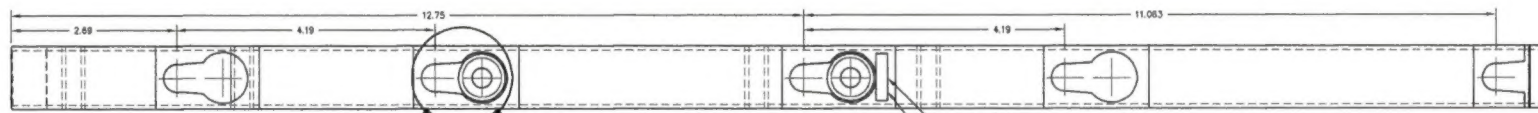
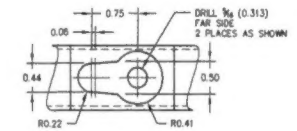
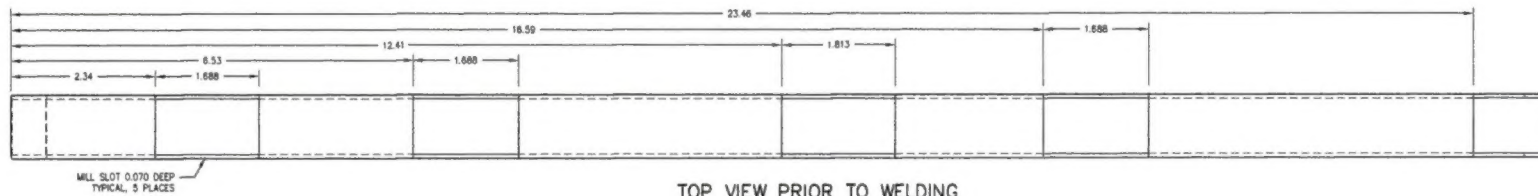
1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2013-58	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
1.	RH Aft Beam	78633-01-01	1			
2.	Forward Beam	78634-01-00	1	N/A	New	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to:				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature		13c. Approved Organization Number		14b. Signature		14c. Approved Organization Number
 Jeff Clarke - AD02		AMF 73-04				
13d. Name		13e. Date (dd/mmm/yyyy)		14d. Name		14e. Date (dd/mmm/yyyy)
Jeff Clarke - AD02		16 Feb 2015				
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

TRU

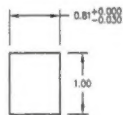
1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2013-58
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	RH Aft Beam	78633-01-01	1		
2.	Forward Beam	78634-01-00	1	N/A	New
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jason Rekve – AD01		13e. Date (dd/mm/yyyy) 12 Jan 2015		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					



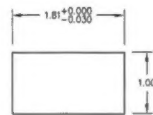
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THE DESIGN OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DISSEMINATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.			
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 78632	BJC	APR 01/10
1	CHANGED PADS	BJC	JUNE 06/12



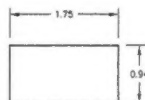
01 78634-01-00 BEAM ASSEMBLY



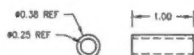
11 PAD



12 PAD



04 CAP



05 BUSHING



03 PAD

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
3. ALL STEEL PARTS TO BE THOROUGHLY DEGREASED AND POWDER COATED PRIOR TO ASSEMBLY.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	78634-12	12	PAD	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
1	78634-11	11	PAD	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
2	MS21044C3		NUT	304 STAINLESS STEEL	COMMERCIAL	12mm X 70mm SPRING
2	#10-32		C SUNK SCREW	304 STAINLESS STEEL	COMMERCIAL	12mm X 70mm SPRING
2	69830-23	10	SPRING	304 STAINLESS STEEL	COMMERCIAL	12mm X 70mm SPRING
2	69830-22	09	KNOB	6061-T6 ALUMINUM	QQ-A-200/8	40.75 ROD
2	69830-21	08	STOP	6061-T6 ALUMINUM	QQ-A-200/8	40.825 ROD
2	69830-11	07	GUIDE	304 STAINLESS STEEL	ASTM A240	40.75 X 0.065 RND. TUBE
1	69830-07	06	BLOCK	304 STAINLESS STEEL	ASTM A479	0.188 SQR. ROD
4	78630-04	05	BUSHING	304 STAINLESS STEEL	ASTM A289	40.375 X 0.058 RND. TUBE
1	78634-04	04	CAP	321 STAINLESS STEEL	AMS 5510	0.025 SHEET
3	78634-03	03	PAD	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
1	78634-02	02	TUBE	304 STAINLESS STEEL	ASTM A354	1 X 2 X 0.065 TUBE
1	78634-01-00	01	BEAM ASSEMBLY			

LIST OF MATERIALS

APPROVALS		DATE	AERO DESIGN LTD.	
DRAWN:	JEFF CLARKE	01 APR 2010	CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M	
CHECKED:	E. BURGIN		2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7	
			tel: (403) 260-8027 fax: (403) 260-8333 www.aerodesign.ca	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			EUROCOPTER AS350 & AS355 SERIES ATTACHMENT PROVISION BEAM FABRICATION	
DECIMALS	X.XXX ±0.010	ANGLES	±1/2°	
X.XX	±0.03			
X.X	±0.1			
SCALE 1 : 1		DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1		A1	78634	1